

May-31-12 9:11:04 AM

Page 1

Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 30/05/2012 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 11/06/2012 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Date: 12/05/31

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84981

May-31-12 9:11:04 AM

84981

Page 2

Item ID: D4030-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Long Basket Assembly (350)

Start Date: 30/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

PIP 84980

0.00

Packaging

P-12/6/1 F(1)

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCJ 12/06/08
mf
12-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 84981

84981

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 30/05/2012

Required Date: 11/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC IPP Rev D 12.03.27 per NCR12-1239 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4086-200

Manufactured No

Each 20.0000

**

D4086-200

Placard, Max Load

Location

Loc Qty

Loc Code

ST093

20

72051

1

82827

7

84416

12

D2530

Manufactured No

100 Each

9.0000

**

D2530

Handle Weldment

Location

Loc Qty

Loc Code

ST506

9

82895

1

83423

8

D2535

Manufactured No

100 Each

77.0000

**

D2535

Spring

Location

Loc Qty

Loc Code

ST504

77

83545

77

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 2

Work Order ID: 84981

84981

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 30/05/2012

Required Date: 11/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2537 Manufactured No

100 Each 44.0000 2

D2537

Bushing

**

Location

Loc Qty

Loc Code

ST504

44

82896

44

D3913-041 Manufactured No

100 Each 0.0000 1

D3913-041

Long Basket Base Assembly, 350

D3914-041

Manufactured No

100 Each 0.0000 1

D3914-041

Long Basket Lid Assembly (350)

D3917-3

Manufactured No

100 Each 0.0000 6

D3917-3

Washer

D3953-3

Manufactured No

100 Each 23.0000 2

D3953-3

Gas Spring Stud, Lid

**

Location

Loc Qty

Loc Code

ST075

23

82939

23

D3953-7 Manufactured No

100 Each 33.0000 2

D3953-7

Spring Spacer

**

Location

Loc Qty

Loc Code

ST075

33

82940

33

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

Work Order ID: 84981

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

84981

D4030-041

Start Date: 30/05/2012

Required Date: 11/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3953-9

Manufactured No

100 Each

42.0000

2

2

D3953-9

Gas Spring Washer

**

Location

Loc Qty

Loc Code

ST075

42

82035

2

82941

40

D3953-17

Manufactured No

100 Each

27.0000

2

2

D3953-17

Gas Spring Spacer

**

Location

Loc Qty

Loc Code

ST075

27

82937

27

D3953-19

Manufactured No

100 Each

40.0000

1

D3953-19

Gas Spring Bracket

**

Location

Loc Qty

Loc Code

ST075

40

82938

40

D3953-21

Manufactured No

100 Each

5.0000

1

D3953-21

Gas Spring Bracket

**

Location

Loc Qty

Loc Code

ST075

5

81456

5

May-31-12 9:11:09 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

Work Order ID: 84981

84981

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 30/05/2012

Required Date: 11/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3969-3

Manufactured No

100

Each

48.0000

1

D3969-3

Spring (Basket Lid)

**

Location

Loc Qty

Loc Code

ST272

48

64285

1

81887

7

82942

40

AN3-14A

Purchased

No

100

Each

89.0000

4

AN3-14A

Bolt

**

Location

Loc Qty

Loc Code

ST352

89

121415

14

121444

25

121708

50

AN3-16A

Purchased

No

100

Each

123.0000

2

AN3-16A

Bolt

**

Location

Loc Qty

Loc Code

ST352

123

117441

47

118628

1

120986

25

121708

50

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Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 5

Work Order ID: 84981

84981

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 30/05/2012

Required Date: 11/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN5-17A

Purchased

No

100

Each

90.0000

4

4

AN5-17A

Bolt

**

Location

Loc Qty

Loc Code

338

6

121181

6

ST338

84

117872

34

121541

50

AN4-12

Purchased

No

100

Each

59.0000

3

AN4-12

Bolt

**

Location

Loc Qty

Loc Code

ST357

59

118626

1

119775

8

121652

50

AN310-4

Purchased

No

100

Each

144.0000

3

AN310-4

NUT

**

Location

Loc Qty

Loc Code

ST344

144

120124

1

120518

17

121011

1

121349

25

121827

100

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Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 6

Work Order ID: 84981

84981

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 30/05/2012

Required Date: 11/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN310C4

Purchased

No

100

Each

44.0000

2

AN310C4

**

Nut

Location

Loc Qty

Loc Code

ST344

44

120360

19

121166

3

121444

22

MS21042L3

Purchased

No

100

Each

2,320.000

6

MS21042L3

**

Nut

Location

Loc Qty

Loc Code

ST300

2320

117885

32

119017

1039

119075

138

121349

259

121444

852

MS21042L5

Purchased

No

100

Each

1,443.000

4

MS21042L5

**

Nut

Location

Loc Qty

Loc Code

300

500

121652

500

ST300

943

108827

8

116105

5

116548

43

117611

18

119109

861

17651

8

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Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Page 7

Work Order ID: 84981

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

84981

D4030-041

Start Date: 30/05/2012

Required Date: 11/06/2012

Start Qty: 1.00

Required Qty: 1.00

MS24665-151

Purchased

No

100

Each

211.0000

3

MS24665-151

Cotter Pin

**

Location

Loc Qty

Loc Code

ST309

211

17566

211

100

Each

157.0000

2

MS24665-300

Purchased

No

MS24665-300

Cotter Pin

**

Location

Loc Qty

Loc Code

GA

153

118234

153

ST309

4

116823

4

100

Each

810.0000

6

NAS1149F0432P

Purchased

No

NAS1149F0432P

Washer

**

Location

Loc Qty

Loc Code

ST275

810

121350

810

100

Each

984.0000

4

NAS1149F0563P

Purchased

No

NAS1149F0563P

Washer

**

Location

Loc Qty

Loc Code

ST275

984

121350

984

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-31-12 9:11:09 AM

Page 8

Work Order ID: 84981

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

84981

D4030-041

Start Date: 30/05/2012

Required Date: 11/06/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

100

Each

676.0000

8

8

NAS1149F0332P

WASHER

**

8

Location

Loc Qty

Loc Code

ST275

676

117735

13

119225

10

120986

200

121259

200

121584

36

25

121585

14

121825

200

17317

3

7

NAS1149C0432R

Purchased

No

100

Each

3,970.000

2

2

NAS1149C0432R

Washer

**

12678

Location

Loc Qty

Loc Code

ST297

1114

117291

114

119124

1000

ST298

2856

121255

2856

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

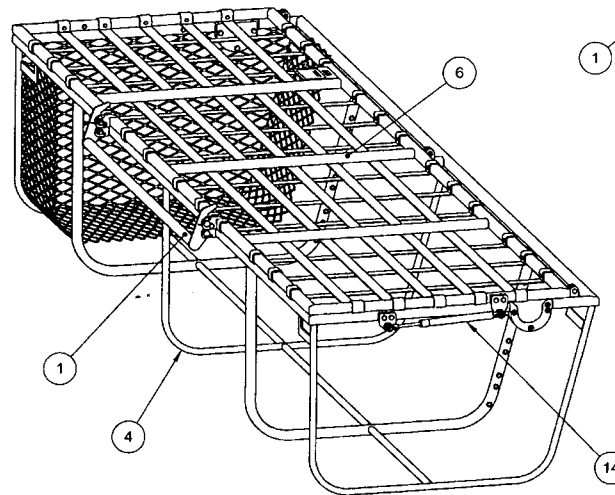
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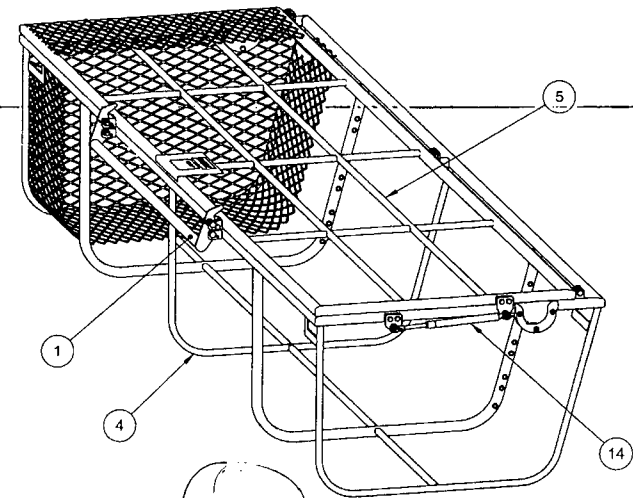
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 84981 MLJ
12/05/31



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

RELEASED
10.09.17
ECN 10-596

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D6-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3)	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALJ	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP		
CHECKED	JFS	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4030	SHEET 1 OF 3
APPROVED	JFS	TITLE	SCALE
DE APPR.	JFS	LONG BASKET ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

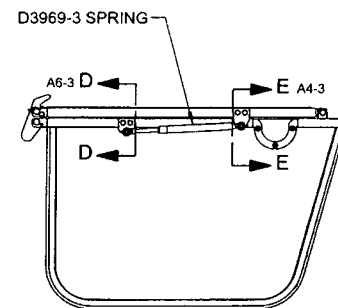
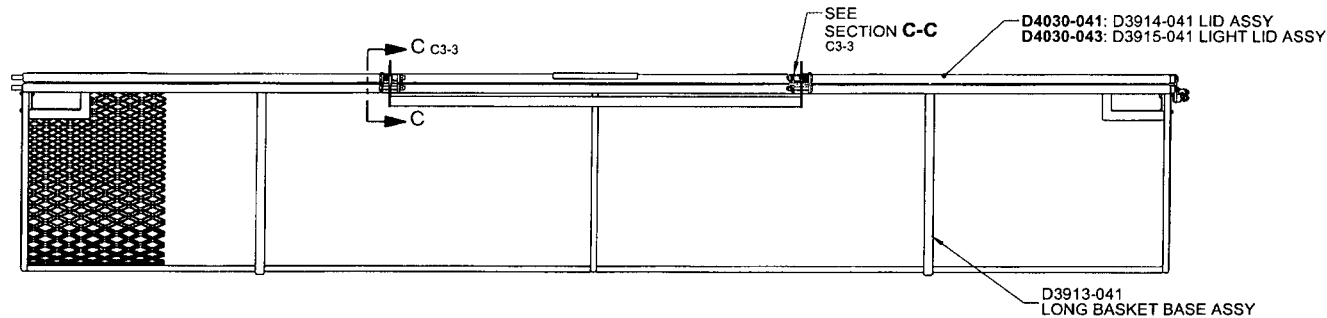
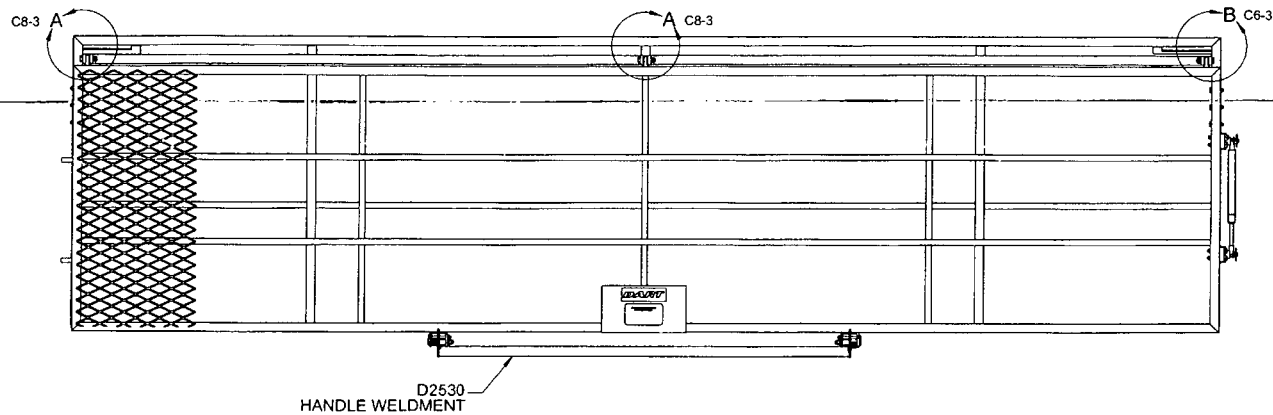
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

BY 981



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	h	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SR	DRAWING NO. D4030	REV. C
MFG. APPR.	SES	SHEET 2 OF 3	
APPROVED	MY	SCALE	
DE APPR.	MY	LONG BASKET ASSY (350) NTS	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

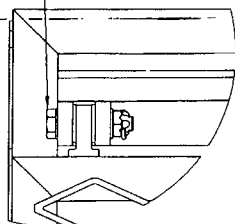
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

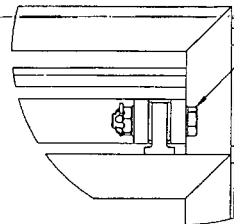
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



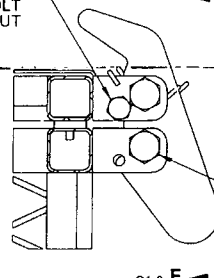
DETAIL A D5-2
D5-2



DETAIL B D3-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT

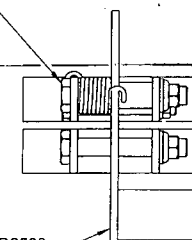


SECTION C-C B4-2
B6-2

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT

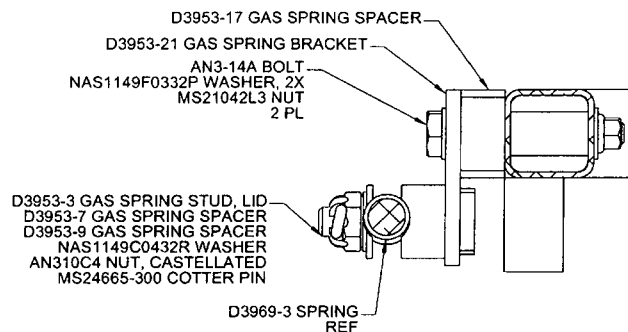
D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

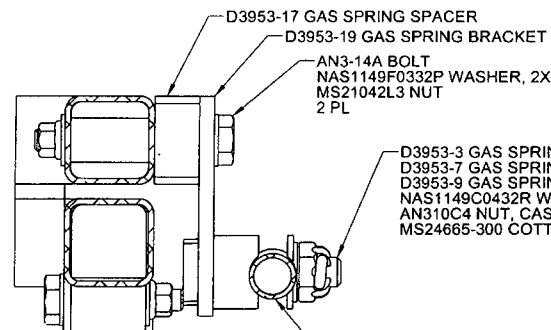


D2530
HANDLE WELDMENT
REF

VIEW F-F C3-3



SECTION D-D B2-2



SECTION E-E B1-2

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

RELEASED
10.08.24

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	J.F.S. B.T.L.	D4030	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET-ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries